

7/22/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

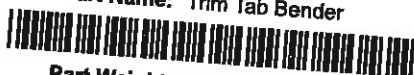
RBH9928-2
Job Sheet 198131



Part No: RBH9928-2

Part Name: Trim Tab Bender

Job Qty: 7 pcs



Part Weight: 0 lbs

Job Created: 7/22/19

Due Date: 9/5/19

Type: SOLD

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG RBH9928-2 Rev K IPP Rev A 17.11.13 New Issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K DP
Verify DD IPP Rev.C 18.01.18 Updated process, all done under assy. JFS Verified by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	7							
		pcs	9/5/19		0.00	0.18	Bandsaw - 1		
110	NV5000 - 1 - B4B	7							
		pcs	9/5/19		1.00	3.50	NV5000 - 1 - B4B		
120	QC 2	7							
		pcs	9/5/19		0.00	0.00	NV5000 - 2 - B4B		
							QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

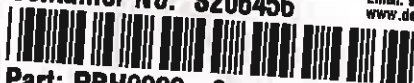
14-08-17
19-08-17

19-08-17



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S206456



Part: RBH9928-2

Job No: 198131

Serial No/Batch: S206456

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 08/17/19

Urgent
S.v.p.
Merci.

130 QC 8	7 pcs	9/5/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mml 12/18/23
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	7 pcs	9/5/19	0.25 3.50	Small Fab - Brake - 1 - B4B	DAS 30 SEP 09 2019 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
155 QC 5	7 pcs	9/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS 81 9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	SEP 09 2019
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
165 Outsource - 4 - Anodize	7 pcs	9/5/19		GRO002-VC ATG001	K4 2019-09-09
175 Packaging 2-1 - Receive -	7	9/5/19	0.00 0.00	Packaging 2 - 1 - B4B	

B4B	pcs			Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
180 QC 6	7 pcs	9/5/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
190 Small Fab - 2 - B4B	7 pcs	9/5/19	0.00 3.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
200 QC 5	7 pcs	9/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

DP SEP 11 2019

DAS
40
SEP 11 2019 9-89DAS
58
SEP 11 2019 9-89

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	81
					QC 5 - 61	9-89
					QC 5 - 81	
210	Packaging 3-1 - Stock - B4B	7 ✓ pcs	9/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	GA-TBD
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220	QC 21 - SA	7 ✓ pcs	9/5/19	0.00 0.00	QC 21 - SA - 21 ✓	GA-TBD
					QC 21 - SA - 70	21 SEP 11 2019
					QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blanks to 8.00"

Descriptions: 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine RBH9928-2-1 & RBH9928-2-3 as per folio FB676

FOLIO REV: AA DWG REV: K 2-Deburr NOTE: ***Machine both parts at same time***

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check) Engrave T/N number ONLY (RBH9928-2) using Marktronic engraver as per DWG.

140 - (Form as per dwg) -Form RBH9928-2-1 as per DWG. -Remove bending marks -Broach RBH9928-2-3 as per DWG. -Tumble to remove buffer marks

155 - (QC5- Inspect part completeness to step on W/O)

165 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO 44447 ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

175 - (Receive & Inspect for Damage & Mat'l Certs)

180 - (QC6- All purchased or subcontracted products)

190 - (Small Fab) -Assemble as per DWG. Sheet 1

200 - (QC5- Inspect part completeness to step on W/O)

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7/22/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

011854

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250X6.250	6061-T651 Sheet 0.250" Thick Plate x 6.250" Wide	4.6620 ft (.666 ea)	100-Bandsaw - 1	5203381
92356A247	Carriage Bolt	14 Ea (2 ea)	190-Small Fab - 2 - B4B	5083965
96659A104	Washer	14 Ea (2 ea)	190-Small Fab - 2 - B4B	5190291
KKT-11A	Knurled Knob	14 Ea (2 ea)	190-Small Fab - 2 - B4B	5191208
				5202020

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6S.250X6.250	5	0	0
190-Small Fab - 2 - B4B	92356A247	14	42	0
	96659A104	14	97	0
	KKT-11A	14	2	0

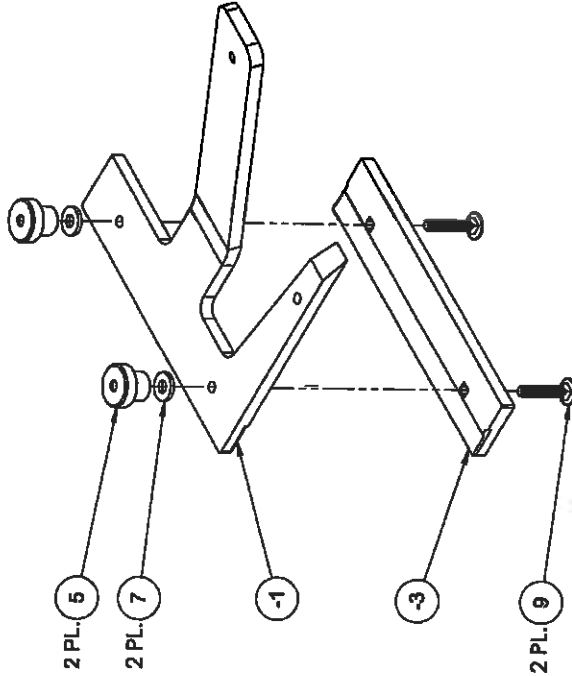
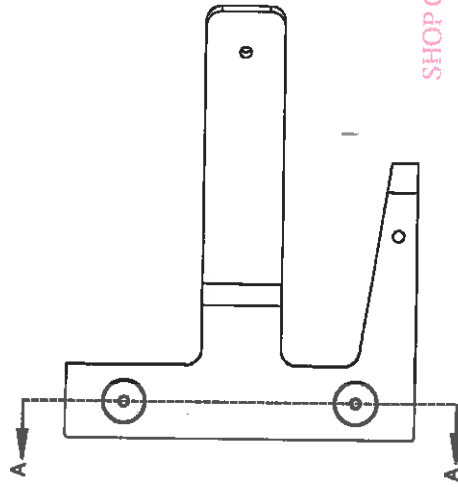
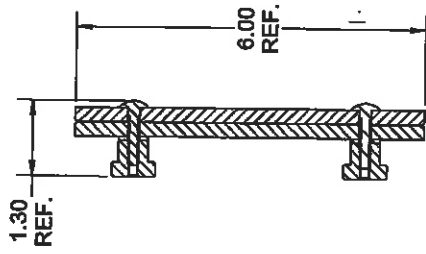
Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	TITLE	PG
-1	1	RBH9928-2-1	TAB BENDER	2
-3	1	RBH9928-2-3	CLAMP	3
5	2	ESSENTIA BKGT-11A	FEMALE KNOB KNURLED	-
7	2	McMaster98658A104	# 10 STAINLESS STEEL 9/16 PLAT WASHER	-
9	2	McMaster92350A247	SQUARE NECK CARTRIDGE BOLT #10-32 X 1" LG.	-

REV.	DESCRIPTION	ECK #	DATE	BY	APPROVED
B	SEPERATED FROM RBH9928	-	06/13	BIM	EB
10	-1 CHTD DISTANCE OF RADIUS FROM .600 (.02) TO .570 (.02) -3 CHTD DISTANCE OF RADIUS FROM .625 (.02) TO .570 (.02) CHD NON-CRITICAL DIMENSION PRECISION FROM .XXX TO .XX.	-	7/8/13	RJC	GE
K	TEMPLATE UPDATED AS PER HAWKSBURY STANDARDS -3 DRILL AND BROACH DIMENSION CHANGED, .1 & .3 RADIUS ALONG THE EDGE DIMENSIONS ADDED, TOLERANCE ADDED ON -1 & -3	17-809	17.06.22	VM	VM



RBH9928-2 TAB BENDER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) USED IN ASSEMBLY RBH9982

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198131 ML5
19-07-22

DART AEROSPACE		Headquarters, Ottawa, Canada	
TITLE TAB BENDER			
QTY REQD	REV	REV	
1	K	RBH9928-2	
DATE	REV	REV	
17/06/2022	1	17/06/2022	
17/06/2022	2	17/06/2022	
17/06/2022	3	17/06/2022	
17/06/2022	4	17/06/2022	
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17/06/2022	97	17/06/2022	
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17/06/2022	100	17/06/2022	

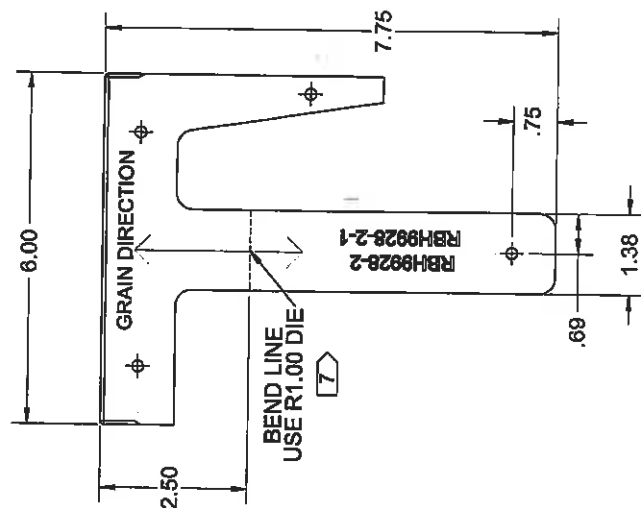
Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>198131</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering ☐	
Part No. <u>RBH9928-2-3</u>		Rework ☐		Cross tube ☐		Eng. (Non-AW) ☐		Water Jet ☐	
		Scrap ☐		Machining ☐		Prod. Eng. Coord. ☐		Supplier ☐	
		Use-as-is ☐		Large Fab ☐		Rec/Store/Packaging ☐		Quality ☐	
Date: <u>2019-08-14</u>		Sequence #: _____		QTY Affected: _____		MRB (Q51042) <u>AP</u>			
Description Work Order Deviation		Disposition							
DIMENSION ☐ 0.200/0.203 CAN BE BROACH AT ☐ 0.188		THIS DEVIATION IS ACCEPTABLE TO USE AS IS FIT, FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED							
Completed By <u>ALA./mrc</u>		Lead hand / Supervisor <u>duf 19/08/19</u>							
QC / QA Coordinator <u>68</u> 9-89		AUG 26 2019							
Root Cause		FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Follo/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Other/Details:									



FLAT PATTERN

PART AEROSPACE

TAB BENDER

RBH9928-2-1

	0	100%	± 50%
B/22/2017			± 50%
			± 50%

11/15/2017	11/15/2017	11/15/2017
------------	------------	------------

11/16/2017	2. INTERPRETATION
11/16/2017	3. DUTY OF CARE
11/16/2017	4. DUTY OF CARE

WEIGHT: 0.5 LBS

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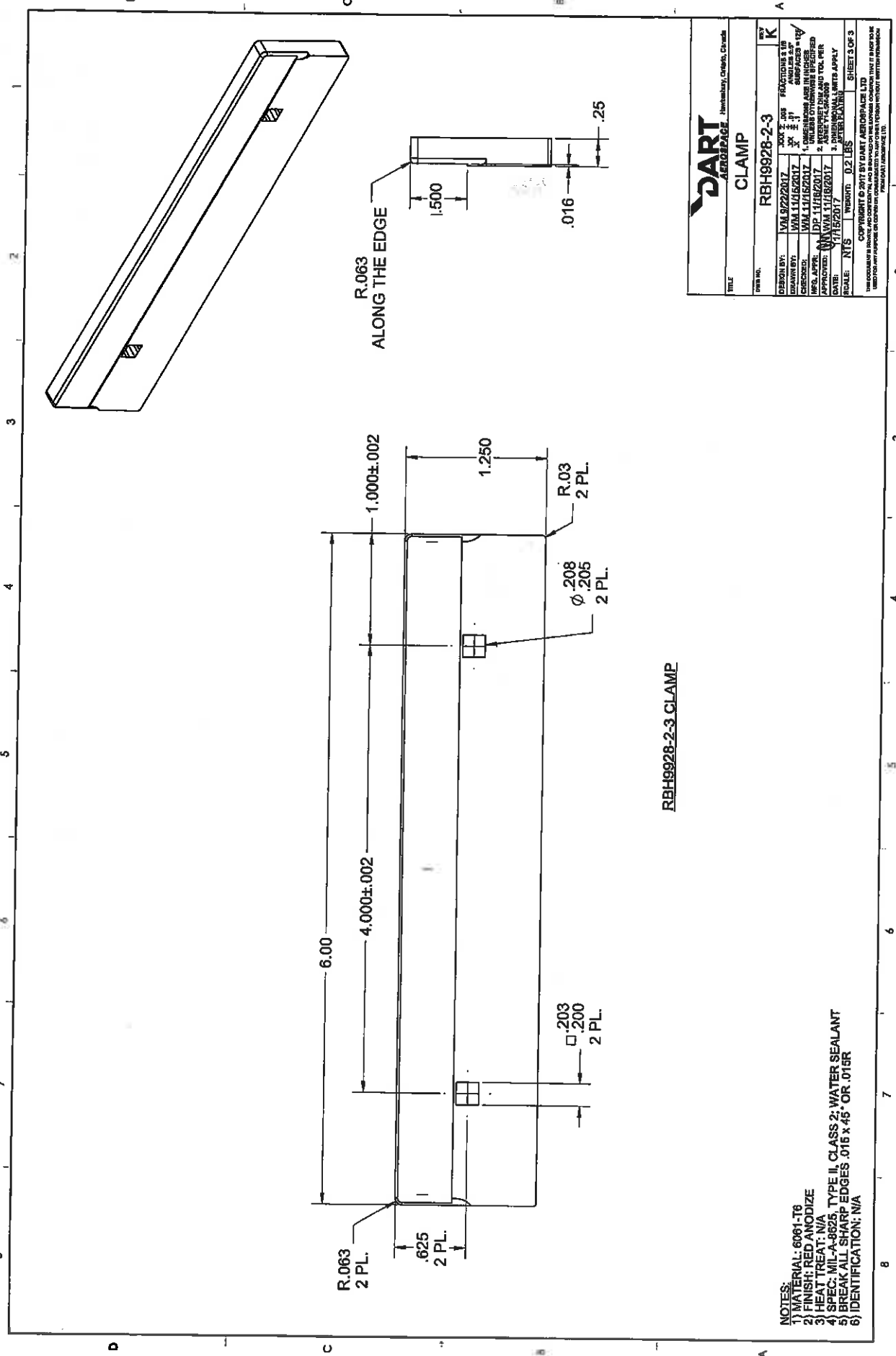
1

RBH9928-2-1 TAB BENDER

NOTES:
1) MATERIAL: 6061-T6
2) FINISH: RED ANODIZE

3) HEAT TREAT: N/A
4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
5) BREAK ALL SHARP EDGES .015 x 45° OR .016R
6) IDENTIFICATION: ENGRAVE T/N & S/N, ARIAL REGULAR,
7) NO DIE MARKS

8



DART AEROSPACE		Hawthornbury, Ontario, Canada	
TITLE		CLAMP	
PWB NO.		RBH9928-2-3	
DESIGN BY:		JACK E. JONES	
DRAWN BY:		JACK E. JONES	
CHECKED BY:		JACK E. JONES	
MFG. APPR:		JACK E. JONES	
APPROVED BY:		JACK E. JONES	
DATE:		11/15/2017	
SCALE:		N.T.S.	
WEIGHT:		0.2 LBS	
SHEET 3 OF 3		REV K	
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- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) FINISH: RED ANODIZE
 - 3) HEAT TREAT: N/A
 - 4) SPEC: MIL-A-8825, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044447**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044447

PO Date: 9/9/19

Due Date: 9/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: **RUSH**

E-MAILED
2019-09-10

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198131	RBH9928-2	Trim Tab Bender Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	9/11/19	7 pcs	0 pcs	7 pcs	\$39.29/pcs	\$275.03

X7

SEP 11 2019

S206456

DP

DAS
40
8-89

Grand Total: \$275.03

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Handwritten signature]

Plex 9/10/19 9:22 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918569

Date: 10-Sep-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
7 ea	Part: RBH9928-2 Trim Tab Bender Anodize per MIL-A-8625F, Type II, Class2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 25901 PO: POHB044447	Rev: K	DAS 40 9-89
		Line: 1	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>SEP 10 2019</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED
SEP 10 2019
DART AEROSPACE LTD.